5/14

DART AEROSPACE LTD	Work Order:	22636
Description: Top	Part Number:	D3249-1
Dwg: D3249 Rev. K 3 1.11.12	Qtv:	10
Dud. 20240 (2017) By / M.		Page 1 of 1

Step	Location	Procedure	γВу	Date	Qty
1	DC	Issue Traveler	KA	05.03.09	10
		1×21/11	<del>10</del>	0,00,07	
2	PG	Issue P/O:	ļ		
		Fabricate D3249-1 as per Dwg D3249			
	-	Possible Supplier: Industrial Laser	1	18/13-10	10
		Material release note is required	11	520,00	0
3	RG	Receive and inspect for transit damage	10		
		Ensure material release note is attached	Las	5/06/08	10
4	QC6	Inspect dimensions as per Dwg D3249	1 1		1.00
1			me	05/07/13	1:0
5	GA	Deburr 5	()	111	100
	• .		mil	05/07/13	10
6	QC5	Inspect work to Step 5			10
				05.03.03	10
7	FP	Chemical Conversion Coat as per QSI 005 4.1		05.08.04	10
'	1	(	TT	05,00,07	10
8	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	10	00 00 10	10
"	' '	, , , ,	KC	050809	10
9	QC3	Inspect Powder Coat	SIL	10 SO 1	10
3	400	mopositi ondo: ood:	11/1	05 109 10	10
10	ST	Identify and Stock	a D		
10		Identify and Stook	CZ	<u>PS/08/11</u>	10
11	AC		1		
		Cost / part			
12	DC	Close W/O			[
		Inspect Level 21	1	<u></u>	

Rev	Date	Change	Revised By	Approved
A	04.05.25	New issue	KJ/JLM	19/
В	04.10.26	D3249-1 no longer made in-house	KJ/JLM (	



H:\Forms\Quality Assurance\Approved QA\IPPSHORT revA

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHA	ANGES					
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
J								
				_				

NCR:		V							
		Description of NC		Corrective Action Section B	Verification	A	Ammerical		
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign & Date	Section C	<b>Approval</b> Design Mgr	Approval QC Inspector	
05/07/13	4	dimension are good except & g 49 holes should be \$ .098 was 0.090 Some pieces are duty		open Holes Ø.098 (49 plo) as drawing 5 \$3049 Smooth Buffing on lach part. (as other Parts)	ml 05/07/13				

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	I/C C	osed:	Date:





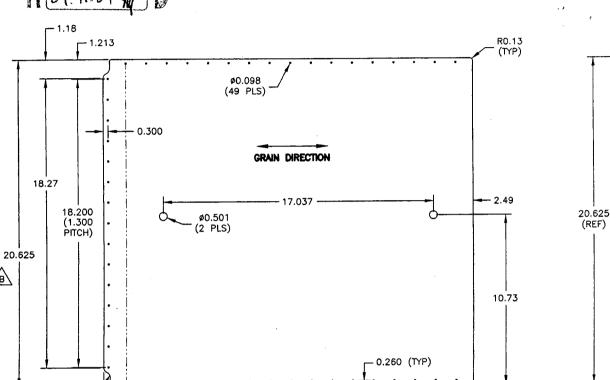
	CHECKED DATE 04.11.04 A	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
ļ	CHECK	(EQ.	APPROVE	DRAWING NO. REV. B
	-	#		D3249 SHEET 1 OF 1
	DATE	<b></b>		TITLE SCALE
	04.1	1.04		TOP (DUAL BATTERY RACK) 1:6
	Α	•	04.04.06	NEW ISSUE
	В		04.11.04	20.625 WAS 20.245

-1.064 (TYP)

β

R0.30

(TYP)



## FLAT PATTERN 0.50 (REF) RO.188 (TYP) 22.29

20.800 (TYP)

(1.300 PITCH)

22.89 (TYP)

23.289

D3249-1 BEND DETAIL

NOTES:

1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCE ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

VICILIORDER

SHOP COPY

**RET'U** 

€NG!

NO. 22636

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## PECHINEY ROLLED PRODUCTS

CERTIFIED TEST REPORT PECHINEY ROLLED PRODUCTS



16497

5052 ITEM ORDERED

PART NUMBER

WEIGHT SHIPPED

ALLOY

ALASKAN COPPER & BRASS 4700 COLORADO AVENUE SEATTLE WA

98124

CUSTOMER PURCHASE ORDER NO. & ITEM

SPEC COIL NON HT

CUSTOMER SPECIFICATION

CLAD.

00

RAVENSWOOD DISTRIBUTOR



LENGTH

DATE SHIPPED

04-09-03

.000

ECHINEY ORDER NO.

WIDTH

GAUGE

.06300

052-880417

48.000

ALASKAN COPPER & BRASS P.O. BOX 3546 WA SEATTLE

98124

T86002 4330 ALASKAN

TEMPER

AMS-QQ-A-250/8

B/L NUMBER

T86000

GOVT, CONTRACT NO.

H32

CERTIFICATION "Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

2

PECHINEY ROLLED PRODUCTS RAVENSWOOD, WV 26164

Mark E. Parsons

MARK E. PARSONS-LABORATORY SUPERVISOR

13,3																			
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## PECHINI ROLLED PRODUCTS

**CERTIFIED TEST REPORT** PECHINEY ROLLED PRODUCTS

LOT NUMBER

ALASKAN COPPER & BRASS 4700 COLORADO AVENUE SEATTLE WA

98124

TEST NO. OF DIRECTION TESTS

YIELD STRENGTH K.S.I.

SEATTLE

ALASKAN COPPER & BRASS P.O. BOX 3546

WA

98124

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								[
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13.34	5	1						

ULTIMATE STRENGTH K.S.I.

CERTIFICATION "Pechiney Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in O conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Pechiney Rolled Products' standard

1

General Terms and Conditions of Sales. Test reports are on file, subject to examination."

**PECHINEY ROLLED PRODUCTS** RAVENSWOOD, WV 26164

MARK E. PARSONS-LABORATORY SUPERVISOR

**ELONGATION %** 

Mark E. Parsons

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